Work Orde				*108	8769*							Page 1
Item ID: Revision ID:	D3912-3		A	Accept	*N9000	14 0	100)*	Setup	Start	*N	S1*
Item Name:	Eyebolt Block	ζ				Ž				Stop	*N	S2*
Start Date: Required Date: Reference:	10/29/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item II Customer:) :						
Approvals:	Process Pla	an: MUJ	Date: 13-10-3)	Tooling:	Da	te:	_		Run	Start	*N	R1*
, sept a seed			Date:	SPC (Y/N):	Da					Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr			·					;		
D3912	В										:	
*100		Cut blanks as per folio		0.00	ml 13/11/1					^ 3		• 2
Bandsaw Jeaspa Bandsaw		Memo CUT BLAN	K 2.50" LONG	0.00	304 1311111						q*.	•
110				0.00	11			,		•	•	
110 HAAS I		Memo		i 0.00	\$13-11-12		.*	U	_ <u>L</u>	<i>Y</i>		
HAAS CNC vertica	ıl machine #1			D DWG	, , , , , , , , , , , , , , , , , , ,							

DEBURR

DQA:			_ Date: _											T
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP			_	AEROSPA	4 C E
QA Closed:			Date:						· · · · · · · · · · · · · · · · · · ·	W	ork Order up	odate only		
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
	•					Rework			Skid-tube	Crosstube	7	Water Jet	Engineering	\neg
Part I	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
						Use-as-is			noforming	Finishing	4	re/Packaging	Other	7
NCR I	۷o.					Suspected Unapproved			Large Fab	Composite	1	Supplier		
											_			
Root					Desc	ription of work order update		Initial	Actio	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	QC Inspecto	or
Design	Щ													
Doc/Data	\sqsubseteq		•											
Equip/Tooling	Щ											-		
Handling/Pre	\vdash													
Material	\vdash													
Operator	Н													
Offset/Setup	H													
Process	\vdash						l							
Supplier Training	Н													
Transport	H					•								
Unapproved														
· · · · · · · · · · · · · · · · · · ·			<u> </u>	l	1		FAI	ULT CA	TEGORY		1		1	
Landi	ng G	Gear				General							······································	
	$\overline{}$	Bending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced	
		Centre N	ot Concer	ntric		BOM/Route		Grain	•		Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	<u></u> -	Temperature/Cu	ire
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Und	qualified	Part Lost/Mi	ssing	Weld	
		Cuffs				Contamination		Instruct	ions Incomplete/Ur	nclear	Part Moved	ļ	Wrong Stock Pul	led
	Ш	Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong		
	-	Heat Trea				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
	\vdash	Inspectio		Tube		Drawing		Misread	1					
	\vdash	Marks/Ch			<u> </u>	Drill Holes	\vdash	Off-set						
	$\overline{}$	Turning S			<u> </u>	Finish		1	Calibration					
I	ı	Wave/Tw	ist in Tub	e	1	Fit/Function		Out of	Seguence					

Work Orde		8769			3769*		. 1.7.	· 		Page 2
Item ID: Revision ID: Item Name:	D3912-3 Eyebolt Block		1 1. Mar 1 (15 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	Accept	*N90004	010 0)* s	Setup Sta	I VI	S1* S2*
Start Date: Required Date: Reference:	10/29/13 10/29/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item ID: Customer:					
Approvals:		n:	Date:	Tooling: SPC (Y/N):	Date:		F	Run Sta Sto	1/1	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID Tool	# Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*1.20 *1.20* QC Quality Control		QC2- Inspect parts off n Memo	nachine FAI/FAIB	0.00	Sf 13-11-12		6	Ø		
130 *130*		QC8- Inspect parts - sec	ond check	0.00	D. a 13/11/12		6	ф		0A3 08 28
QC Quality Control		Memo		0.00	13/11/12			Ψ		6-83

Identify as per dwg & Stock Location: 57144 0.00

160 Packaging

Packaging

Memo

0.00

DAS 33 9-89

DQA:		- Date:											` [™] ∂ΔRT	,
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / U		Worl	k Order up	date only	AEROSPACE	
NA/ and a Onel					DISPOSITION				AGAINST	DEPA	RTMENT/	PROCESS		1
Work Orde	er:				D avvo alv	,	1	arrive [,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	-	1
Dort N	ul o				Rework			Skid-tube	Crosstube	_	D	Water Jet	Engineering	1
Part N	NO				Scrap Use-as-is			Machining noforming	Small Fab	_		d. Eng. Coor.	Quality	Ì
NCR I	No				Suspected Unapproved		mem	Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier	Other	
NCN	.				Suspected Ollapproved	۱ . ا		raige rab	Composite	لــا		Supplier		
Root				Desc	ription of work order update		Initial	Ac	tion		Sign &			1
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	QC Inspector	1
Design														٦
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material														ı
Operator														
Offset/Setup														
Process														
Supplier														
Training														1
Transport											ļ			
Unapproved														
						FAI	ULT CAT	TEGORY					•	٦
Landi	ng Gear				General		_							
	Bending			L	Bend		Folio/P	rogram		o	utside Dime	ensions	Pressure/Forced	
	Centre N	ot Concer	ntric		BOM/Route	L	Grain			o	ver/Under t	tolerance	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	re		Pa	art Incorrec	t [Temperature/Cure	
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspecti	on Incomplete/U	nqualified	Pa	art Lost/Mis	ssing	Weld	1
	Cuffs				Contamination		Instruct	ions Incomplete/	Unclear	Pa	art Moved	Γ	Wrong Stock Pulled	
	Crushing				Countersink		Misalig	ned/off center	[Po	ositioned W	/rong		
	Heat Tre				Cut Too Short		Mislabe	led	[Po	ower Loss/S	Surge	Other	
		n Strip in	Tube		Drawing		Misread	1	•					٦
	Marks/C				Drill Holes		Off-set							1
		Sequence			Finish		Out of 0	Calibration						٦
	Wave/Tv	vist in Tub	e .	- 1	Fit/Function		Out of S	Sequence						٦

Work Orde	er ID 10			*108	3769*				· - · ·			Page 3
Revision ID:	D3912-3 Eyebolt Block			Accept	*N9000	040	100)*	Setup	Start Stop	*N *N	S1* S2*
Start Date: Required Date: Reference:	10/29/13 10/29/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item II Customer:) :						
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Da				Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 170 *170* QC Quality Control)	Operation Description QC21- Final Inspection - Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	, 3/11	Reject Number	Insp. Stamp

DQA:			Date:											DAADT
						WORK ORDER NON	-CO	ONFO	RMANCE / L	JPDATE				AEROSPACE
QA Closed:			Date:								W	ork Order up	date only	
Work Orde	ir.					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
WORKOIGE	·' -	, ,			-	Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	-	Pro	d. Eng. Coor.	Quality
	_					Use-as-is	1		noforming	Finishing	-		e/Packaging	Other
NCR N	۱o					Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Desc	ription of work order update	1	Initial	A	ction		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Des	cription		Date	Verification	QC Inspector
Design	_													
Doc/Data	_													
Equip/Tooling	_	:			:									
Handling/Pre	-													
Material	_													
Operator														
Offset/Setup	\dashv	İ					İ							
Process	-					٠								
Supplier	-													
Training Transport														
Unapproved	\dashv				l									
Gilappiovea			l	!			FΔ	ΠΕΤ CΔ1	TEGORY	· · · · · · · · · · · · · · · · · · ·				<u> </u>
Landir	ng Ge	≘ar				General		OLI CA	IEGORI					
[Bending				Bend		Folio/F	rogram		Г	Outside Dim	ensions [Pressure/Forced
		Centre No	ot Concen	itric		BOM/Route		Grain	J		Г	Over/Under	├	Set-up
		Cracks				Broken/Damage/Defect	T	Hardwa	ire		一	Part Incorred	_	Temperature/Cure
		Crimp/Kin	ık/Ripple,	/Wave		Burrs	Г	Inspect	ion Incomplete/l	Unqualified		Part Lost/Mi	}	Weld
[Cuffs				Contamination		Instruct	ions Incomplete	/Unclear		Part Moved	· ·	Wrong Stock Pulled
		Crushing				Countersink		4	ned/off center			Positioned V		
] [leat Trea	t			Cut Too Short		Mislabe	eled		Г	Power Loss/:	Surge Γ	Other
[1	nspection	n Strip in	Tube		Drawing		Misread	.			-	_	•
] [Marks/Ch	atter			Drill Holes		Off-set						
	1	Turning S	equence			Finish		Out of 0	Calibration					
	Ιk	Nave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					

Picklist Print

October-29-13 10:01:54 AM

Work Order ID:

108769

Parent Item:

D3912-3

Parent Item Name:

Eyebolt Block

Start Date: 10/29/13

Required Date: 10/29/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ir L	M303B1.000X1.000		Purchased	No			100	f	13.2000	0.208	1.313684	4		
.	* 303 BAR 1" X 1"													

 Location
 Loc Qtv
 Loc Code

 MAT031
 13.2

 m126724
 13.2

1.32 and 13/11/10

DQA:		_ Date:										AADT
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	۱۸/	ork Order up	odata only	AEROSPACE
QA Closed.		Date.							VV	ork Order up	date only	1
Work Orde	er:				DISPOSITION			ÁGAI	INST DE	PARTMENT	/PROCESS	
					Rework	1		Skid-tube Crosst	tube]	Water Jet	Engineering
Part N	No.				Scrap			Machining Small	· ·	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming Finis	hing	1	e/Packaging	Other
NCR I	No				Suspected Unapproved			Large Fab Compo	osite		Supplier	
			.,									
Root				Desci	ription of work order update	1	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling			}									
Handling/Pre	\Box					l						
Material	\blacksquare					i						·
Operator	H											
Offset/Setup									-			
Process	H					ŀ						
Supplier Training	H											
Transport	H											
Unapproved											•	
.,	<u> </u>		<u> </u>			FAI	ULT CA	TEGORY				
Landi	ng Gear	·			General					- · · · · · · · · · · · · · · · · · · ·	-	
	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Centre N	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks		,		Broken/Damage/Defect		Hardwa	re		Part Incorred	ļ	Temperature/Cure
	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing	g			Countersink		Misalig	ned/off center		Positioned W	Vrong	_
	Heat Tre	eat	*,		Cut Too Short		Mislabe	eled		Power Loss/:	Surge	Other
	Inspection	on Strip in	Tube		Drawing		Misread	d				
	Marks/C				Drill Holes		Off-set				-	
		Sequence			Finish		Out of (Calibration				
	Wave/T	wist in Tub	oe e	1	Fit/Function	1	Out of	Sequence			· · · 	

DART AEROSPACE LTD	Work Order:	108769
Description: Eyebolt Block	Part Number:	D3912-3
Inspection Dwg: D3912 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	loiciunoc	Dimension	Accept	, Acject	Inspection	Comments
2.30	+/-0.030	2.301			5108	Vein
Ø0.129	+0.005/-0.001	.130			Gauge	Pin
0.50 Ref	+/-0.030	.495	1/		1	
R0.13	+/-0.030	125	V		Rad ga	uae
0.500	+/-0.010	.496	V		1	9
R0.125	+/-0.010	.125			Rad G	nucl
0.63	+/-0.030	.626	V		١	
0.750	+0.000/-0.020	.735				·
0.38	+/-0.030	.374	//			
1.500	+/-0.010	1.497				
0.500 Pitch	+/-0.010	.498	/			
0.800	+0.000/-0.010	.795			/	
0.400	+/-0.010	.398				
0.516	+0.015/-0.000	.527			1/	
1.00	+/-0.030	.993	V		V	
			_			

	00					
Measured by:	\mathcal{M}	Audited by:	A.0	DAG	Preliminary Approval:	
Date:	13-11-12	Date:	13/11/12	5-45	Date:	

	Rev	Date	Change	Revised by	Approved
	Α	10.06.07	New Issue	KJ (A	1
	В	12.05.15	Dwg Rev updated	KJ (A)	(WIII
•		,		V	

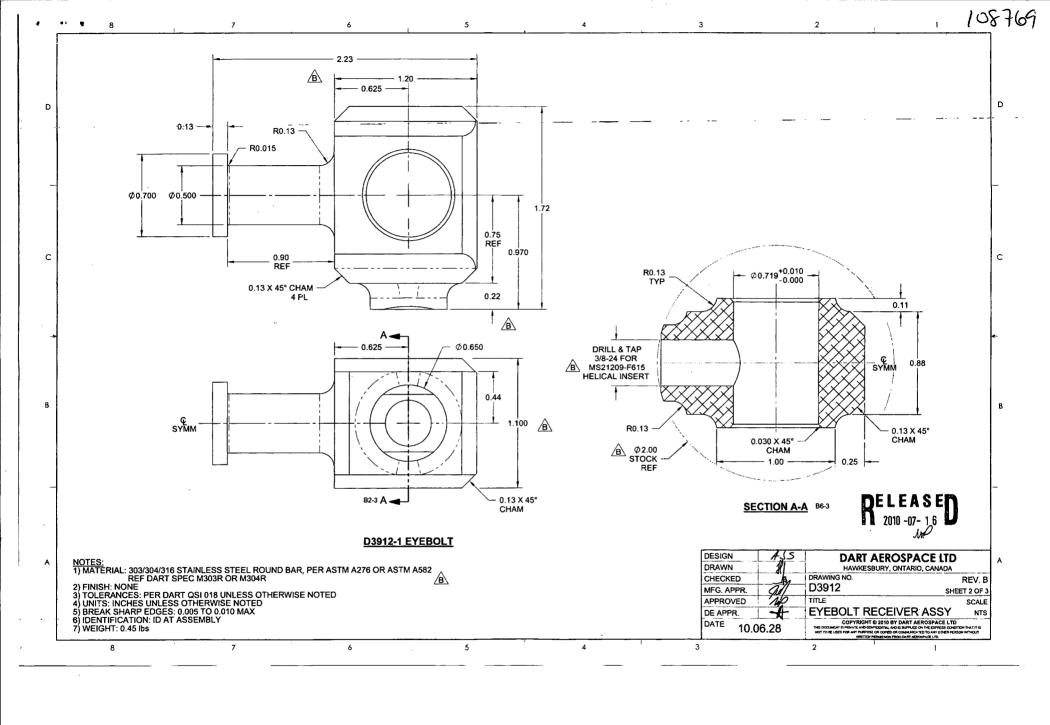
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	ITEM	QTY -041	P/N	DESCRIPTION								
}		X	D3912-041	EYEBOLT RECEIVER ASSY								
ŀ	1 2	1 2	D3912-1 D3912-3	EYEBOLT BLOCK								
Ì	3	2	D3912-5	EYEBOLT PLATE					\rightarrow			_
P	4	1	D3801-1	SPRING PLUNGER	<u> </u>			(/				D
	5	- 8	-MS20615-4M20	RIVET ··-	· ·			(-				Г
	6	1	MS21209-F615	HELICAL	B							
	7	1	NAS1149F0332P	WASHER	3					REF		-
С							2					С
•					5 8X	·		SUPPLEME (EYEBOLT P TO SHOW INTO	NTAL ISO VIEW LATE REMOVED ERIOR FEATURES)			•
В				Ó	<u>B</u> 46				•			В
							108769	MLJ -10-31	REL 1 2010	EASED		
					D3912-041 EYEBOLT REG	CEIVER ASSY		A NEW ISSUE	D3810-1 SPRING PLUNGER; D4 5 WAS MS21209-C610 HELICAL; 3R ADDED; BOSS ADDED TO D:	JPH	10.06.28	
								REV.	DESCRIPTION	BY	DATE	ł
^	111	TES: MATERI INISH:	AL: N/A NONE	018 I INI ESS OTHERWISE NOTED						AEROSPACE L' BURY, ONTARIO, CANA		A

MFG. APPR. D3912 REV. B SHEET 1 OF 3 APPROVED TITLE EYEBOLT RECEIVER ASSY

COPYRIGHT 6 2011 BY CART JEEFOCRACE IN

THE COCCAN'S HOW THE COLOR OF THE DE APPR. NTS DATE 10.06.28

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NIA
6) IDENTIFICATION: IDENTIFY WITH DART PIN D3912-041 USING
FINE POINT PERMANENT INK MARKER 7) WEIGHT -041: 1.58 lbs



-- 0.800+0.000 2.30 Ø0.129 THRU 1.500 4 PL --- 0.400 0.500 PITCH 0.50 REF 1.00 0.750+0.000 R0.13 0.500 R0.125 TYP 0.516+0.015 0.63

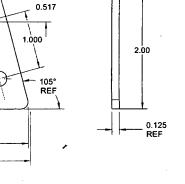
D3912-3 EYEBOLT BLOCK

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

1.500 40.375 R0.13 0.500 PITCH TYP - 0.38 0.25 0.517 1.000 1.500+0.020 105° REF Ø0.129 Ø0.257 8 PL 2 PL 3.65 3.69 REF



D3912-5 EYEBOLT PLATE

DART AEROSPACE LTD DESIGN DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3912 MFG. APPR SHEET 3 OF 3 TITLE **APPROVED** SCALE **EYEBOLT RECEIVER ASSY** DE APPR. NTS COPYRIGHT @ 2010 BY DART AEROSPACE LTD DATE 10.06.28